

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011172**Date Inspected:** 28-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-**BAY #10:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel.This QA Inspector generated an MT report for this date.The member is identified as South Lift 4 "BC" Corner Seam.The weld designations reviewed are as follows:-
SSTL4-1B/L-5B.

Ultrasonic Testing:-**BAY # 10:-**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date.The member is identified as Interior Splice Plate.The weld designations reviewed are as follows:

SSD1-SPSA4-20-1,2,3,4A/B

SSD1-SPSA4-16-1,2A/B

SSD1-SPSA4-15-1,2A/B

NSD1-SPSA4-16-1,2A/B

IN PROCESS INSPECTION:-

WELDING INSPECTION REPORT

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BAY #10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA3-1-99M-1-43 located on Strut Plate. Welder is identified as 040268. ZPMC CWI is identified as Mr. Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA3-1-99M-1-46 located on Strut Plate. Welder is identified as 053049. ZPMC CWI is identified as Mr. Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

BAY #11:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESTL4-2B/L-7 located on Diagonal Plate. Welder is identified as 040713. ZPMC CWI is identified as Mr. Li Lin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSTL4-2B/L-58A located on "BC" Corner Seam. Welder is identified as 044550. ZPMC CWI is identified as Mr. Yu Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2b-S-2.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSTL4-2L/L-3A located on "BC" Corner Seam. Welder is identified as 040669. ZPMC CWI is identified as Mr. Yu Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-C-U2b-S.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod-13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Pillai, Pandaram

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer